Qty:

Friday, 30/05/2008 10:12:24 AM

Julie Lecocq

Process Sheet

Customer Job Number

: CU-DAR001 Dart Helicopters Services

Drawing Name

: BUSHING

Estimate Number

: 39590 : 11061

P.O. Number

: 30/05/2008

Part Number

: D2915

This Issue Prsht Rev.

: NC

Drawing Number S.O. No. :

: D2915 REV A

: MACHINED PARTS Type

Project Number

: N/A : A

Previous Run

: // : 27903 **Drawing Revision** Material **Due Date**

: 10/06/2008

60 Um:

Each

Written By

Comment

First Issue

Checked & Approved By

02.05.03

: Est

Machined in house NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M303R0750

303 Round Bar .75"



Comment: Qty.:

0.1357 f(s)/Unit

8.1396 f(s)

303 Round Bar .75"

(1.425" long)Material: AISI 303 0.750 DIA

Total:

M107857

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA231

Deburr as required, NO sharp edges

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



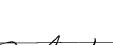
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



4.0

QC8



Comment: SECOND CHECK



PACKAGING 1

PACKAGING RESOURCE #1



5.0



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Part Aerospace Ltd

W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE			В	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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1										
1						8				
1										
 Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQ	A:	Date:	
					Q	A: N/C	Close	d:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	ICR)				
DATE STEP		Description of NC			ction B	v		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Chief Eng	QC Inspector	
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NOTE: Date & initial all entries

Friday, 30/05/2008 10:12:25 AM Date: User: Julie Lecocq **Process Sheet** Drawing Name: BUSHING Customer: CU-DAR001 Dart Helicopters Services Part Number: D2915 Job Number: 39590 Job Number: Seq. #: Description: Machine Or Operation: FINAL INSPECTION/W/O RELEASE 6.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 08-06-05 Job Completion

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W/O:			WC	RK ORDER CHANG	ES				
DATE STEP		PROC	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date:	
							d:	Date: _	·
NCR:		W	ORK ORDI	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37590
Description: Bushing	Part Number:	D2915
Inspection Dwg: D2915 Rev: A		Page 1 of 1

inspection Dwg	: D2915 Rev	. / \			···		<u></u>
	FIRS	TARTICLE IN	ISPECTI	ON CHE	CKLIST		
	X	First Artic	cle	Prot	otype		
Drawing	Toloronos	Actual	Accept	Reject	Method of	Co	mments
Dimension	Tolerance	Dimension	Accept	Velect	Inspection		
1.425	+/-0.010	1.425	1				
0.060	+/-0.005	,059	V				
R0.010	+/-0.010	R0.010					
0.030 x 20°	+/-0.010	°030×90°	V,				
Ø0.750	+/-0.005	Ø .750	J				
Ø0.257	+0.005/-0.000	Ø.257	V				
Ø0.425	+0.000/-0.002	05.474					
			-				
				-			
	/ -						
Measured by:	mm=/05/	Audited by:	me.	2[Prototype Ap	proval:	N/A
Date: (08/06/03	Date:	08/04/	63		Date:	N/A
						viced by	Approved

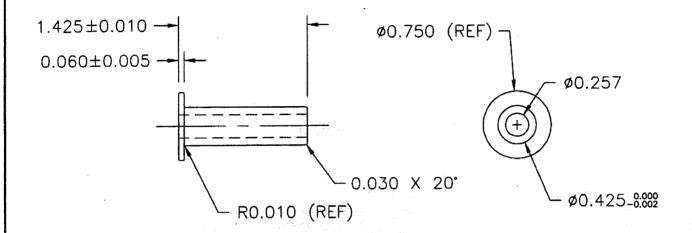
Rev	Date	Change	Revised, by	Approved
Α	04.05.06	New Issue	KJ/RF	L +7





OESIG)	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
CHECK	(ED / C	APPROVED	DRAWING NO.	REV. A
	P	*	D2915	SHEET 1 OF 1
DATE		1	TITLE	SCALE
99.0	9.28		BUSHING	1:1
Α		99.09.28	NEW ISSUE	,





MATERIAL: AISI 303 - 0.75 DIA STOCK
BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SHOP COFY
ALL DIMENSIONS ARE IN INCHES

RETURN TO
ENGINEERING
UNCONTROLLED

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK OR DER